

Date: Thursday, 9/14/2006 7:29:06 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BLOWER INLET ADAPTER
<b>Job Number</b> : 28560	
<b>Estimate Number</b> : 12318	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3473043
<b>This Issue</b> : 9/14/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3473 REV.B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 26990	<b>Material</b> : N/A
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 10/6/2006
<b>Checked &amp; Approved By</b> : <u>[Signature]</u>	<b>Qty:</b> <u>2</u> <b>Um:</b> Each
<b>Comment</b> : est rev. A 06.03.02 new issue EC Est Rev:B As per Rev B 06-05-24 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D34735	VERTICAL TUBE
-----	--------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-5	tube	B270190 B288070

2.0	D34733	COVER
-----	--------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-3	Cover	B27018

3.0	D34739	FLANGE
-----	--------	--------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-9	Flange	B26121 B285090

4.0	D34731	DUCT
-----	--------	------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-1	Duct	B27017 B29251

①

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:29:06 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 28560

Part Number: D3473043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34737

HORIZONTAL TUBE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D3473-7 Tube ~~B 27020~~ B 28588

6.0

AN960C416L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part number Description Batch

2 AN960C416L washer M100651

7.0

NAS1031C3W

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part number Description Batch

6 NAS1031C3W Nutplate ~~M100943~~ M101144

ME. 06-11-08

②

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole as per dwg D3473

FF 06-11-08

2

2-Spot weld as per dwg D3473

ME. 06-11-07

9.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 06/11/08

②

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST351

DB 06/11/09

②

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PP Date: 06/11/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:29:06 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 28560

Part Number: D3473043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ES 06/11/10 (2)

Job Completion



u 06.10.10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

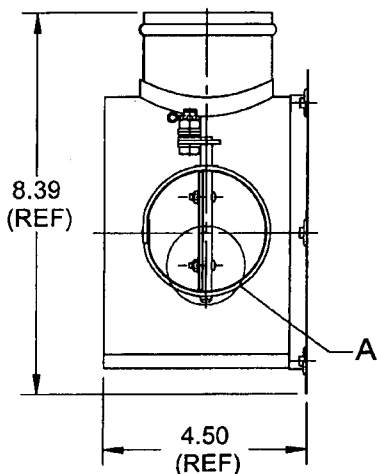
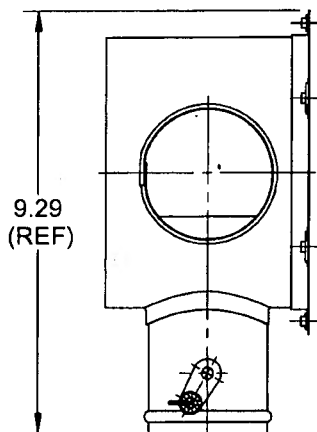
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

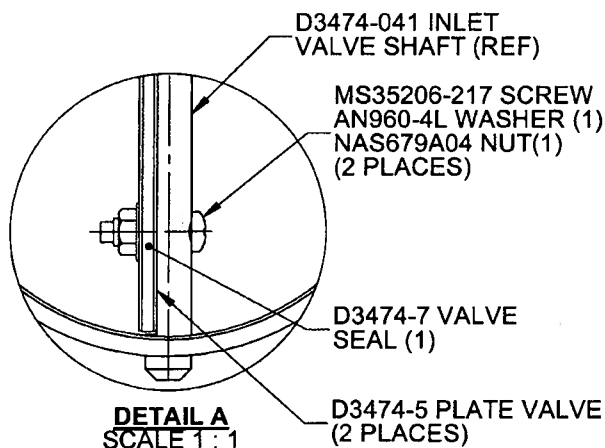
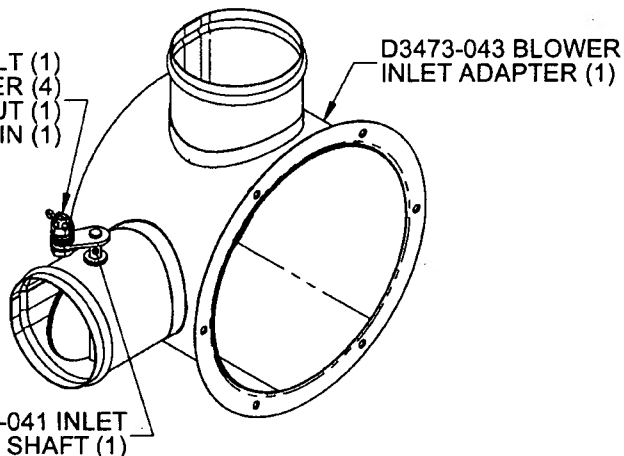
**NOTE:** Date & initial all entries

**DART****RELEASED**  
06-05-16

DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3473</b>	REV. B SHEET 1 OF 7
DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	



D3470-9 BOLT (1)  
AN960-416 WASHER (4)  
AN310-4 NUT (1)  
MS24665-153 COTTER PIN (1)



### **D3473-041 BLOWER INLET ADAPTER**

#### **NOTES:**

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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WITHOUT NOTICE

WORK ORDER

NO. 28560

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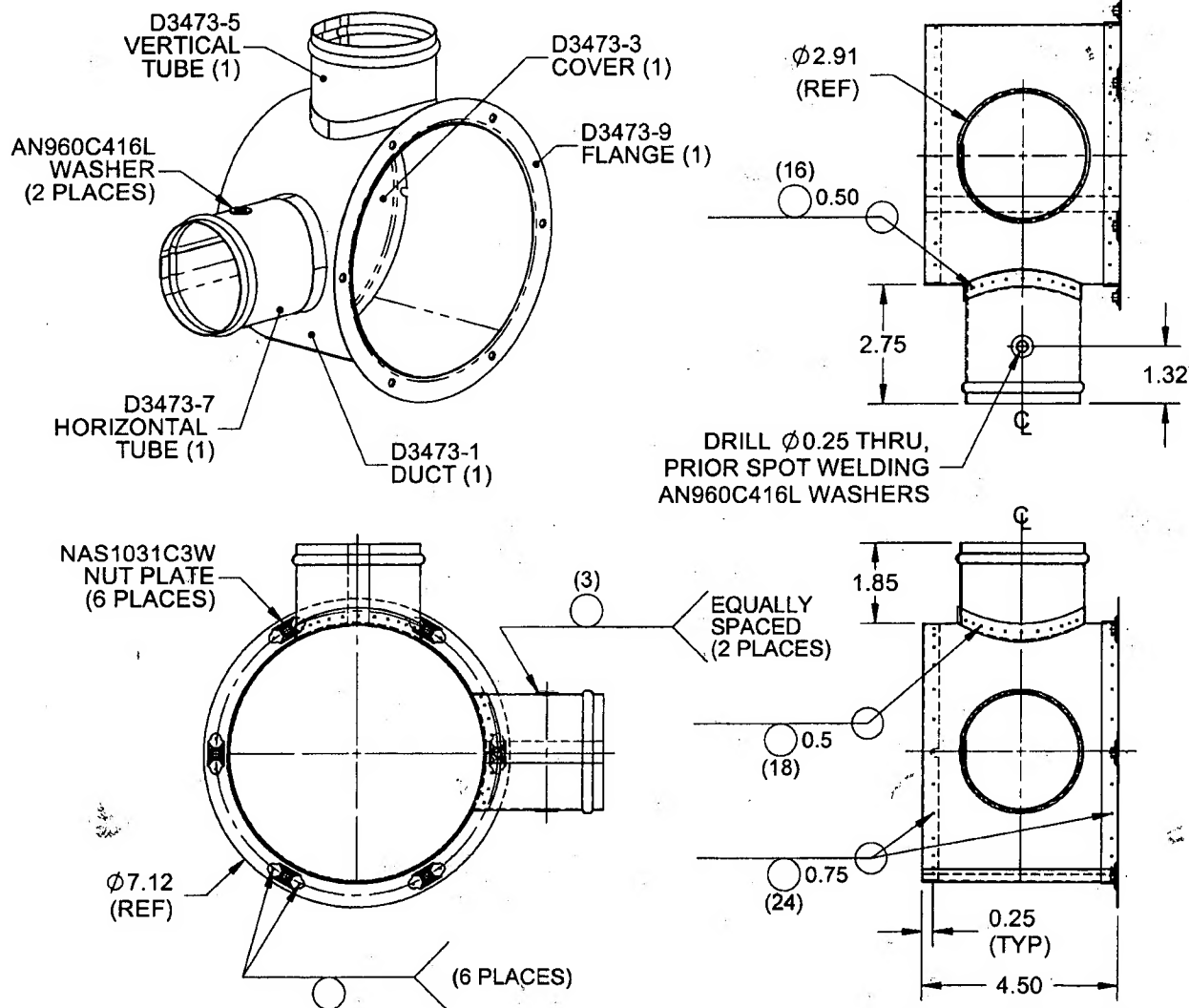
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CHECKED #11	APPROVED #11	DRAWING NO. <b>D3473</b>	REV. B SHEET 2 OF 7
DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4

**RELEASED**  
06.05.16 #11**D3473-043 BLOWER INLET WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

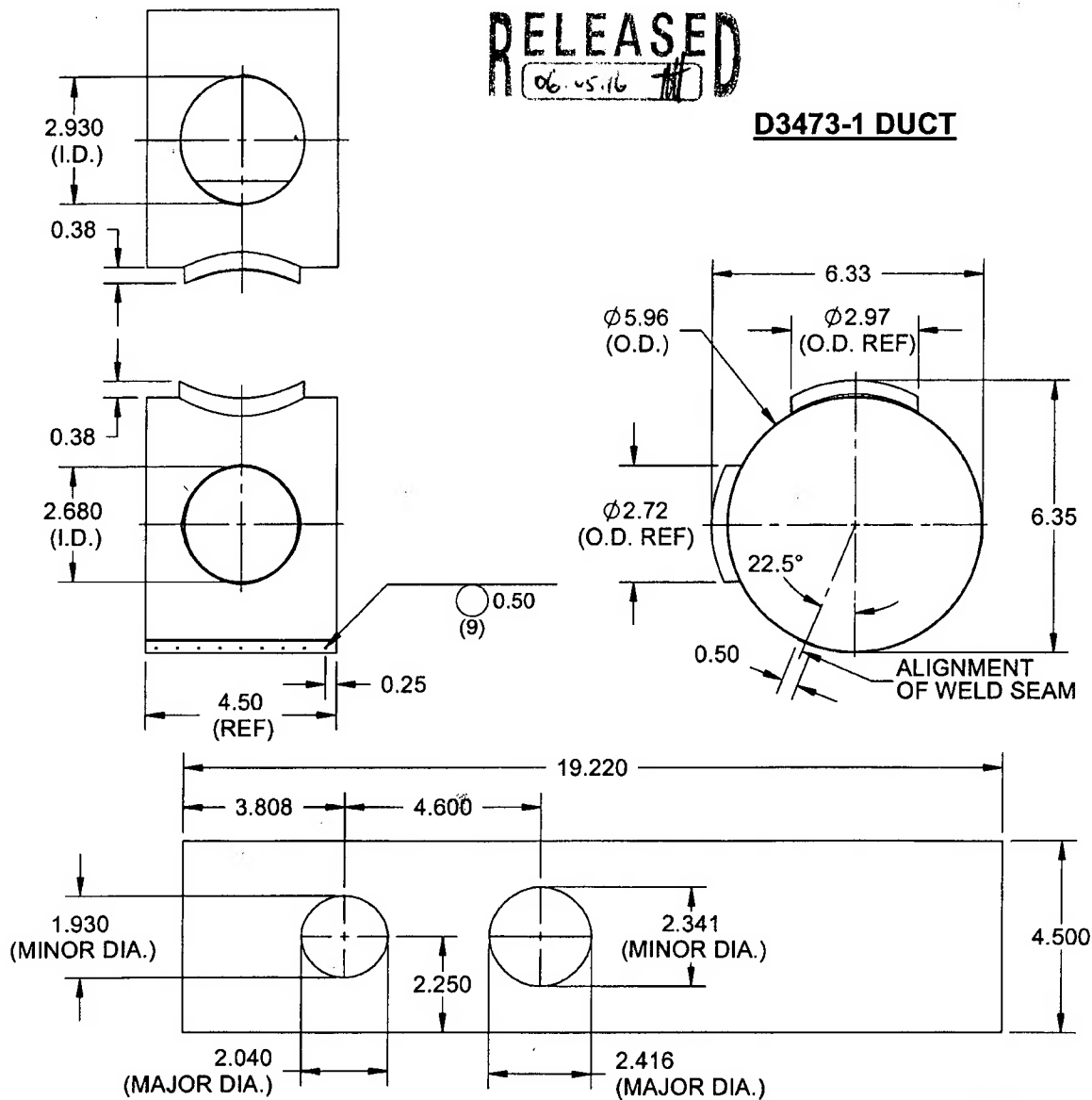
QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT COPY
		RETURN TO ENGINEERING
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
		UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 28560
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4

**RELEASED**  
06.05.16**D3473-1 DUCT****D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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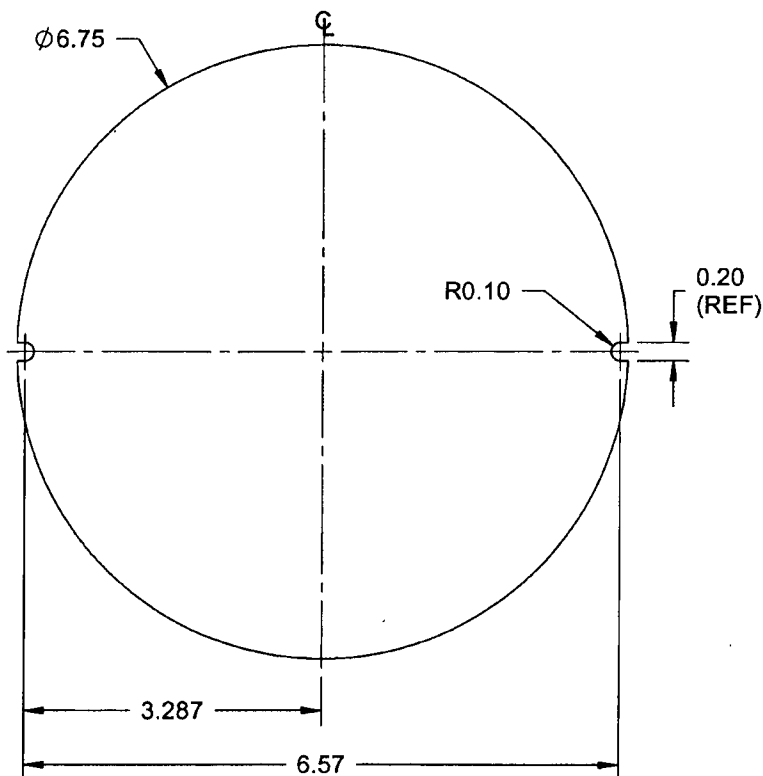
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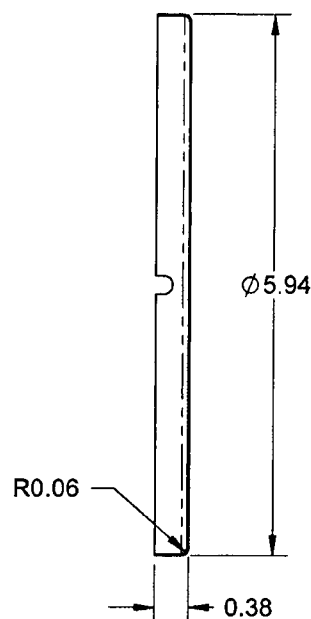


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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

RELEASED  
*06-05-16*



**D3473-3F COVER FLAT PATTERN**



**D3473-3 COVER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

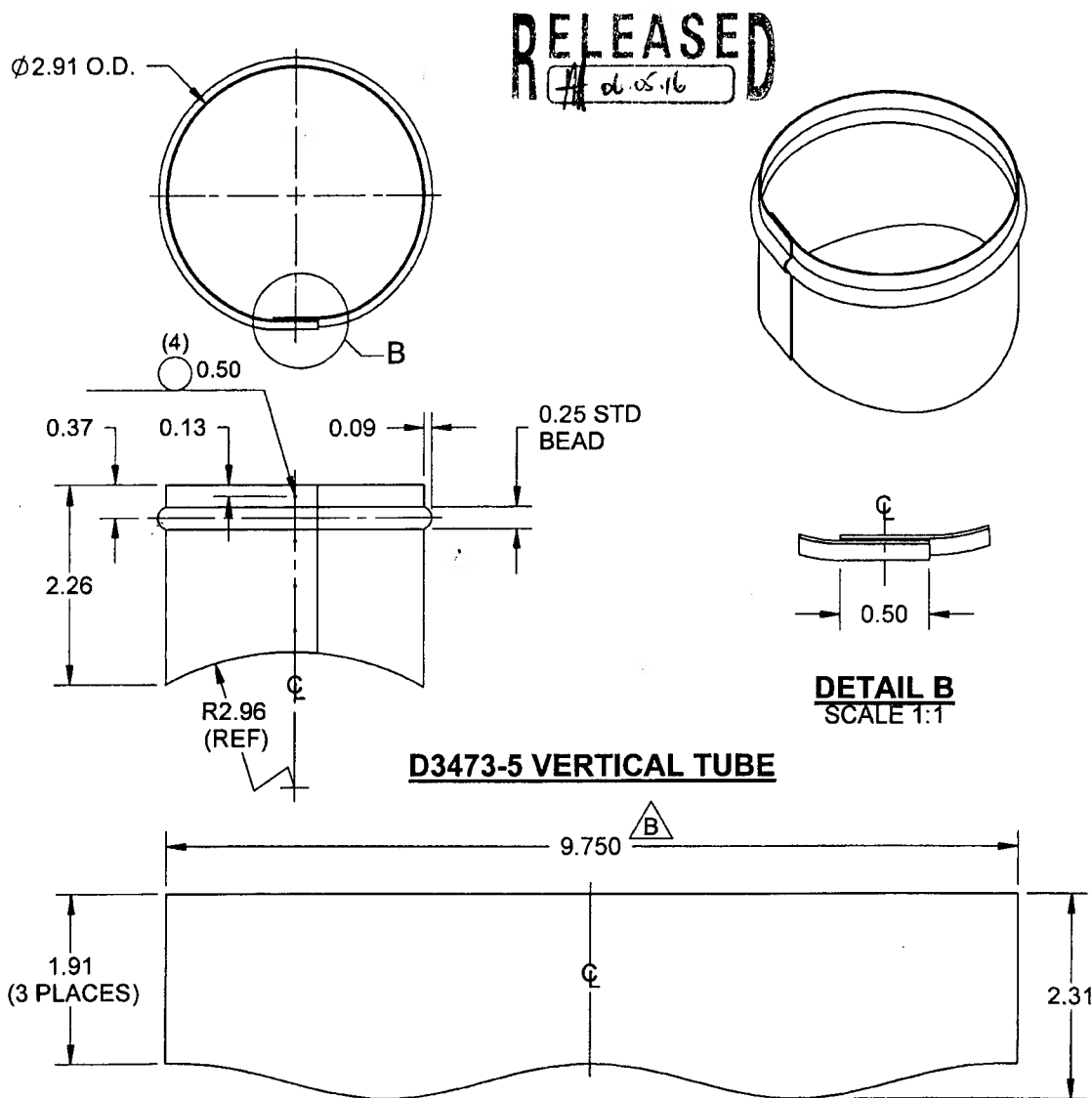
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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 28 FINISH  
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

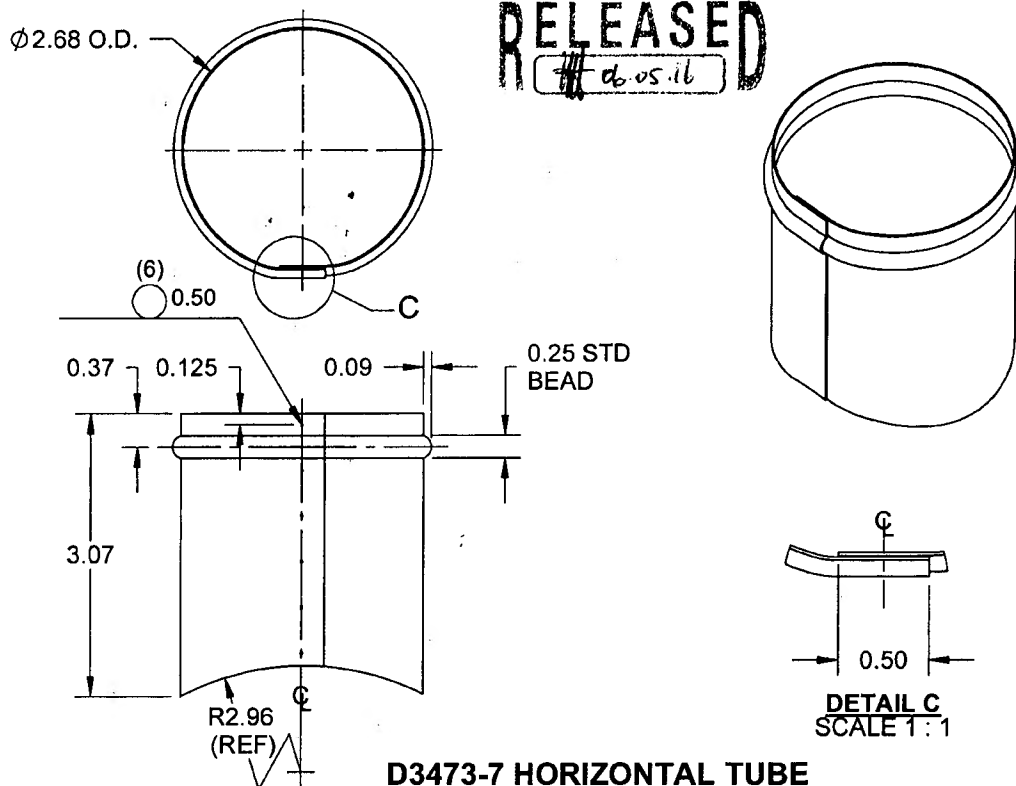
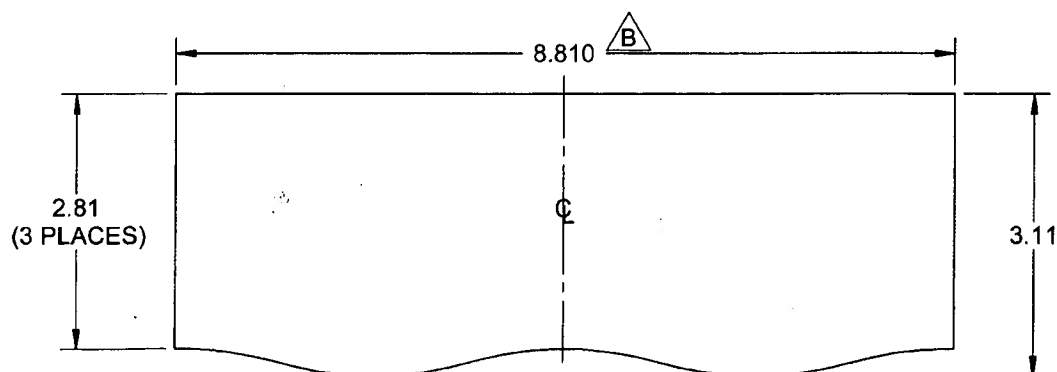
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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

**D3473-7 HORIZONTAL TUBE****D3473-7F HORIZONTAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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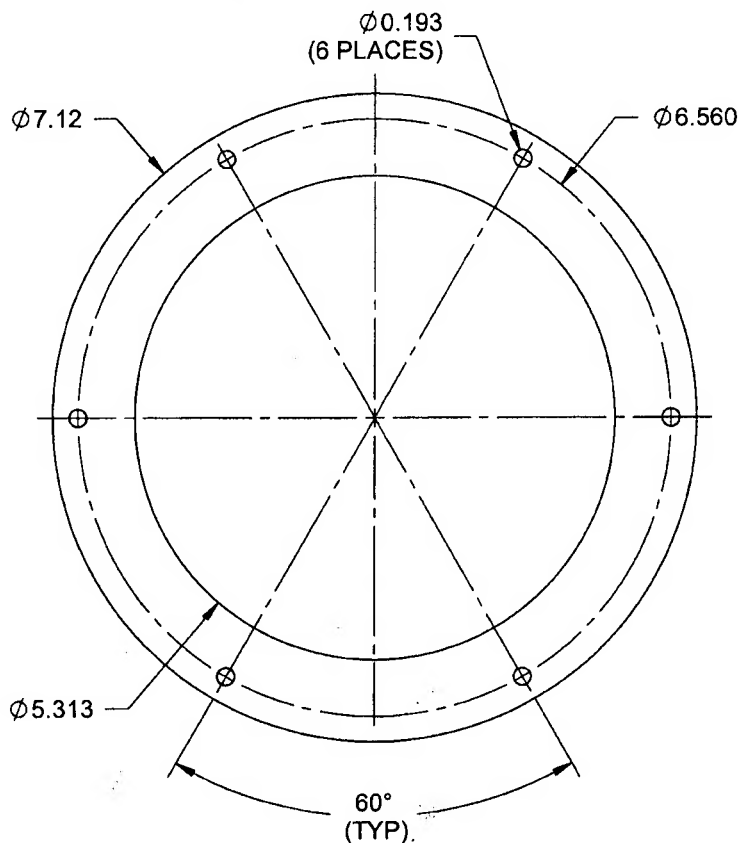
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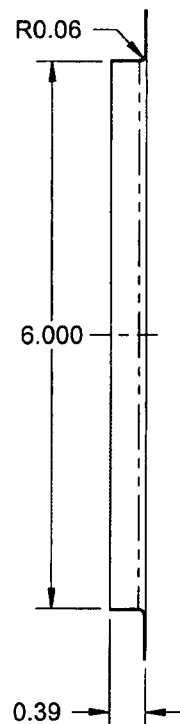


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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED  
*[Stamp]*



**D3473-9F FLANGE FLAT PATTERN**



**D3473-9 FLANGE  
BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 9

EMPLOYEE: Melanie Fautant

PART NUMBER: D3473-043

JOB NUMBER: B 28560

MATERIAL TYPE: 304/316

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PENETRATION:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PULL STRENGTH:	[ <input type="checkbox"/> ]	[ <input type="checkbox"/> ]

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 06/11/03

QUALIFIER: Sylvia Boucher